

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019883**Date Inspected:** 29-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhang Qiang, AB Fluor QA Yu Jiao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SEG3019L-1

Weld No: 085

Welder: 066416

Weld Repair No. B-CWR2645

WPS-345-SMAW-3G(3F)-FCM-Repair

Components; OBG 14E

PCMK: SEG3019U

Weld No: 003

Welder: 216086

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WPS-B-P-2212-TC-U4b-FMC-1

Components; OBG 14E

PCMK: SEG3019AG

Weld No: 041,043,045

Welder: 067571

WPS-B-P-2214-U4b-FCM-1

Components; OBG 14E

PCMK: SEG3019K-1

Weld No: 001

Welder: 215553

Weld Repair No. CWR2668

WPS-345-SMAW-2G(2F)-RP-Repair

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhang Qiang, AB Fluor QA Yu Jiao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG

PCMK: DP3160

Weld No: 134,135

Welder: 066733, 037723

WPS-B-T-2133-ESAB

Components; OBG

PCMK: DP3160

Weld No: 180,181,188,189

Welder: 066733, 037723

WPS-B-T-2133-ESAB

Components; OBG 13AE

PCMK: SEG3007AT

Weld No: 045

Welder: 055564

WPS-B-P-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

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No significant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Kelly
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken
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QA Reviewer
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